



Dart Hawkesbury
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D4635-142

Job Sheet 167085-M



Part No: D4635-142

Job Qty: 1 ea

Part Name: Fwd Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Aug Rev F
DAS 10 9-89

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start Up Small Fab	<i>D.M.L 18-2-17</i>
100	Small Fab	1 pcs		11/9/17	0.00	0.80	Small Fab	<i>D.M.L 18-2-17</i>
110	Small Fab	1 pcs		11/10/17	0.00	0.80	Small Fab	<i>D.M.L 18-2-17</i>
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	<i>PD FEB 2 2018</i>
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	<i>PD FEB 2 2018</i>
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	<i>DAS 21 FEB 2 2018</i>

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-142 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4635-2 <i>F164293</i>	1	2	0	0
	D4669-1 <i>5006911</i>	2	27	0	0
	D4695-042 <i>5025805</i>	1	1	0	0
	D4732-3 <i>5008985</i>	1	4	0	0
	D4732-31 <i>5009001</i>	1	4	0	0
	D4732-35 <i>8009003</i>	1	5	0	0
	D4732-7 <i>5008987</i>	1	2	0	0
	D5022-1 <i>50341014</i>	1	4	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
NCR No. _____		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Large Fab ☐	Composite ☐	Supplier ☐				

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation	Disposition	Completed By
Dart Aerospace Ltd. 1270 Aberdeen Street Newmarket, ON Y6A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 02/17/18		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause Environment ☐ No R ☐ Design ☐ Oper ☐ Doc/Data ☐ Offs ☐ Equip/Tooling ☐ Suppl ☐ Handling/Pre ☐ Traini ☐ Material ☐ Use fr ☐ Internal Transport ☐ Poor l ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Loss/Surge ☐ rogram ☐ Stock Pulled ☐ Sequence ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____		Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐			

Container No: S043458

Part: D4635 - 142

Job No: 167085 - M

Serial No/Batch: S043458

Revision: D4635

Inspector: